

Date: Thursday, 29/05/2008 11:09:36 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR DOUBLER
Job Number :	39576		
Estimate Number :	12942		
P.O. Number :		Part Number :	D3594044
This Issue :	29/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3594 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	38165	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	JUD 08.5.29	Due Date :	06/06/2008
Comment :	Est Rev :A New Issue 07-01-22 EC	Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s)

6061-T6 .080 Sheet

Batch: 107904 HB 8-6-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: A HB 8-6-3

Prog Rev: A

2-Deburr if necessary HB 8-6-3

⑩

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-6-3

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/06/03 x 10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

CP 08/06/03 ⑩

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Drawing Name: DOOR DOUBLER

Job Number: 39576

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 08-06-04

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-06-04

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/06/04 (18)

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Anchor nuts

BATCH: *M107938*

CF 08/06/10

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivet

BATCH: *M1021*

CF 08/06/10

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

CF 08/06/10 (10)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/10 (10)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Stayo*

P-8/6/11 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 11:09:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 39576

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/12 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-06-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

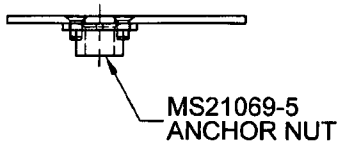
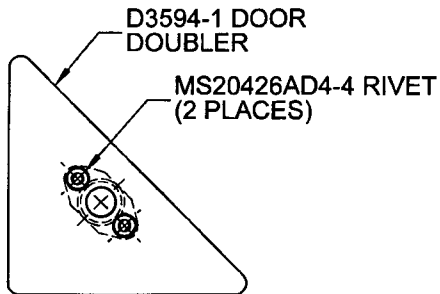
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

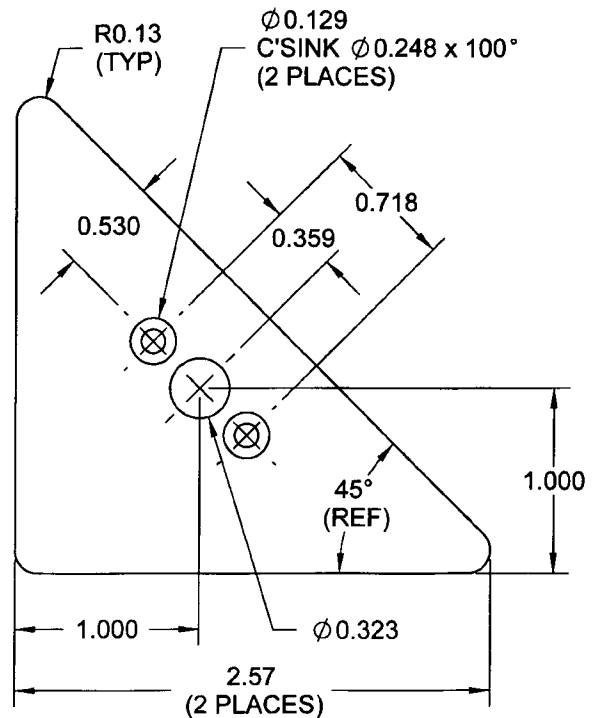
NOTE: Date & initial all entries

DART**RELEASED**
07.07.11
Per [signature]

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3594	REV. A SHEET 1 OF 3
DATE 07.04.13	TITLE DOUBLER		SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3594-041 DOOR DOUBLER ASSEMBLY**
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET

**D3594-1 DOOR DOUBLER** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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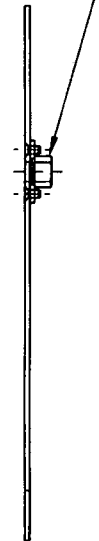
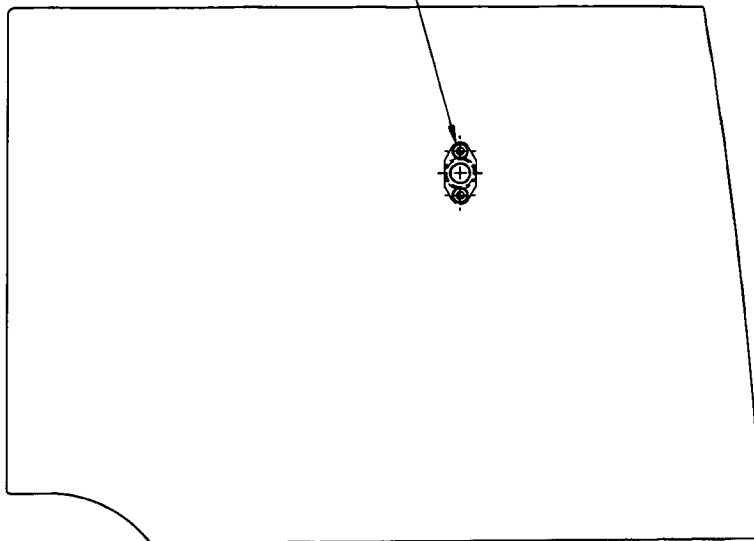
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CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3594	REV. A SHEET 2 OF 3
DATE 07.04.13		TITLE FLOOR DOUBLER ASSEMBLY SCALE 1:3	

RELEASED
07.07.11

Per 60 #1021

MS20426AD4-4 RIVET
(2 PLACES)MS21069-5
ANCHOR NUTD3594-3 FLOOR DOUBLER (D3594-043)
D3594-4 FLOOR DOUBLER (D3594-044)**D3594-043 FLOOR DOUBLER ASSEMBLY**
(D3594-044 OPPOSITE)

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

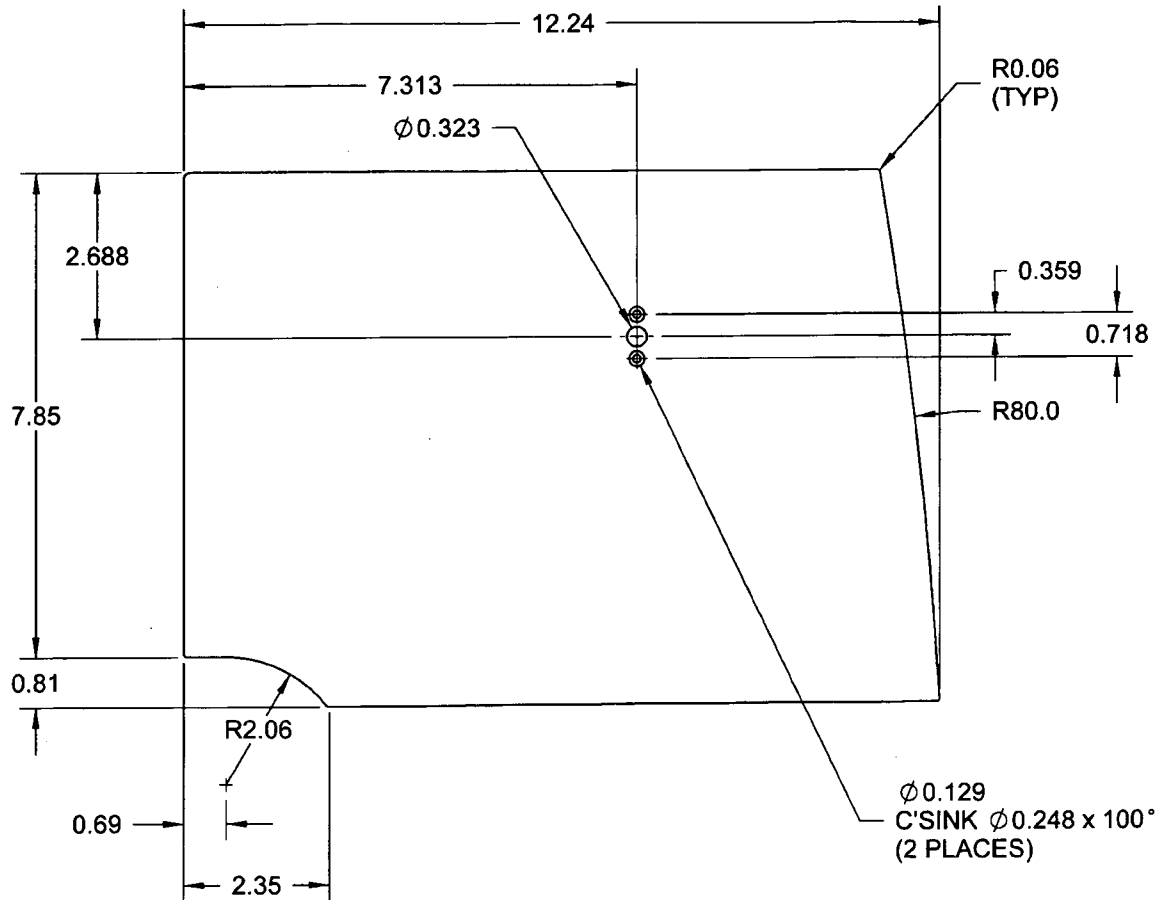
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CHECKED 13	APPROVED 13	DRAWING NO. D3594	REV. A SHEET 3 OF 3
DATE 07.04.13		TITLE DOUBLER	SCALE 1:3

RELEASED
07.07.11 13
PER 60041001



D3594-3 FLOOR DOUBLER
(D3594-4 OPPOSITE)

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